

Work Order ID 62214

Wednesday, September 22, 2010 11:46:42 A



Page 1

Item ID: D3235-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Lug

Start Date: 9/22/2010 Start Qty: 50.00



Cust Item ID:

Required Date: 9/29/2010 Req'd Qty: 50.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date: 10-9-22

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3235	Rev A

100



Bandsaw

Jeaspa Bandsaw

BAND SAW

0.00

Memo

0.00

Cut D2423 extrusion to 0.820"

Batch:

*Issue PO 12709
Machine per drawing D3235 Rev A*

110



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

1-Machine as per Folio FA369 and Dwg D3235

2-Identify as D3235-1

3-Deburr

120



QC

Quality Control

QC2- Inspect parts off machine FA1/FA1B

0.00

*Review + Inspect for transit damage
Memo
Ensure CS of C attached*

CL 10/10/07 (50)

CL 10/10/07 (50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




Work Order ID 62214

Wednesday, September 22, 2010 11:46:42 A

Page 2

Item ID:	D3235-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Mounting Lug					
Start Date:	9/22/2010	Start Qty:	50.00		Cust Item ID:	
Required Date:	9/29/2010	Req'd Qty:	50.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8 Inspect parts - second check QC6 Memo	0.00 0.00		8/10/10/10/1		counter x50			
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00		=> HL 10/11/10/1		x50	Ø		
160  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 9:25 OVEN TEMPERATURE: 320° FINISH TIME: 9:55	0.00 0.00				50	HL 10-11-2		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

[REDACTED]

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Accept

[illegible]**Setup Start**

Stop

Cust Item ID:[illegible]

Customer:

Reference:

Run Start

Stop

Operation	Description
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Set Up/ Run Hours

Tool ID**Tool #**

Plan Code

Accept
Qty

Reject
Qty

Reject Number

**Insp.
Stamp**

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Identify as per dwg & Stock Location: *St 971*

0.00

[REDACTED]

Packaging

Memo

0.00

Packaging

QC21- Final Inspection - Work Order Release

0.00

[REDACTED]

QC

Memo

0.00

Quality Control

MF

10-11-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, September 22, 2010 11:46:46 AM

Page 1

Work Order ID: 62214



Parent Item: D3235-1



Parent Item Name: Mounting Lug



Start Date: 9/22/2010

Required Date: 9/29/2010

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP ☐ A ☐ 04.04.19 ☐ New issue ☐ KJ/JLM ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3235-1P 		Purchased	No			100	Each	0.0000	1	50			
lug													
D2423 		Manufactured	No			110	f	357.1094	0.0683	3.594737			
Lug Extrusion													

Location

Loc Qty

Loc Code

MAT06

357.1093795

43722

180

45800

177.109379

MF 10-11-02

CY 10/11/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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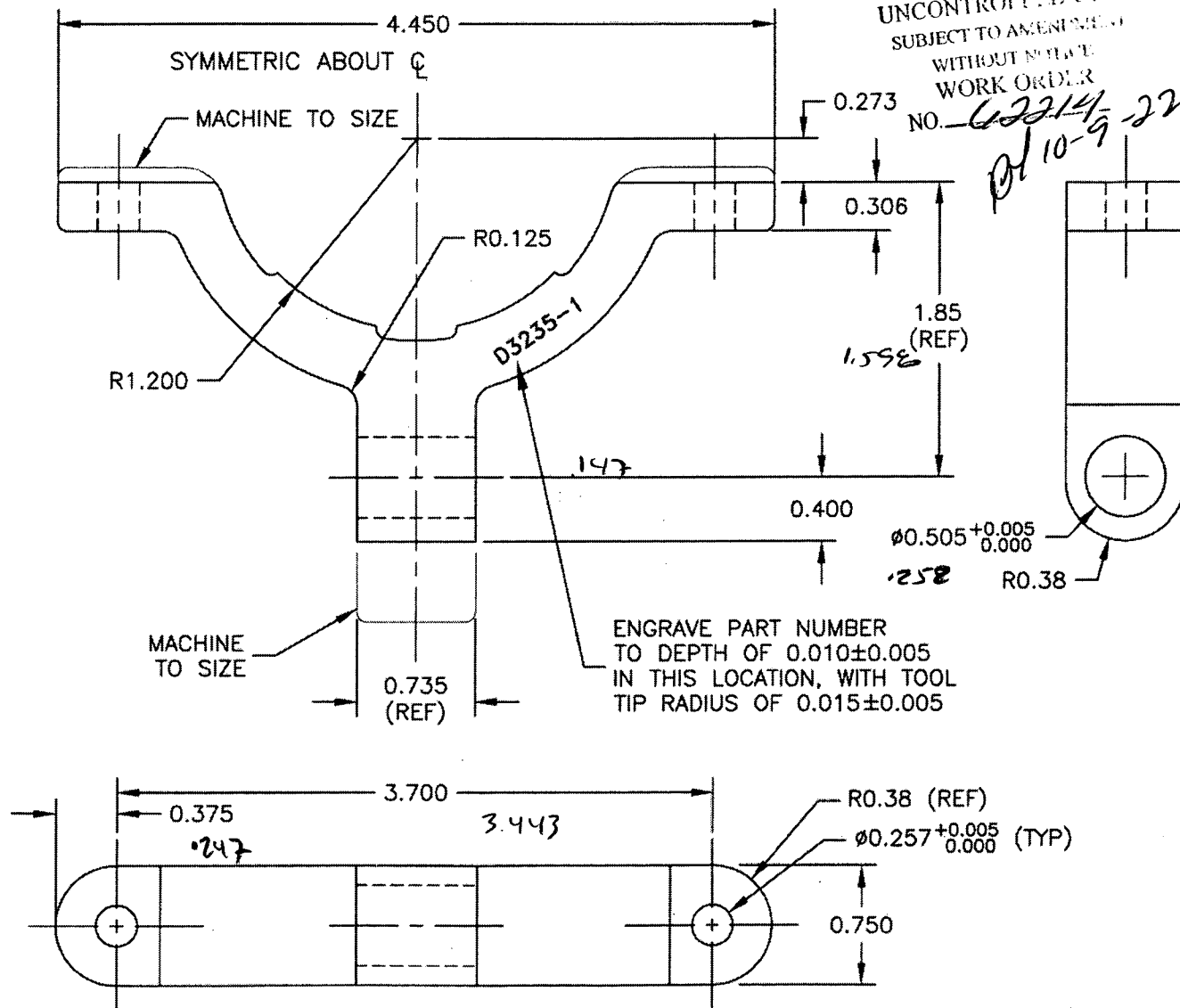
NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3235	REV. A SHEET 1 OF 1
DATE 04.03.02		TITLE MOUNTING LUG	SCALE 1:1
A	04.03.02	NEW ISSUE	

RELEASED
040405

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 62214-22
010-9-22



D3235-1 MOUNTING LUG

MAKE FROM EXTRUSION D2423

BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

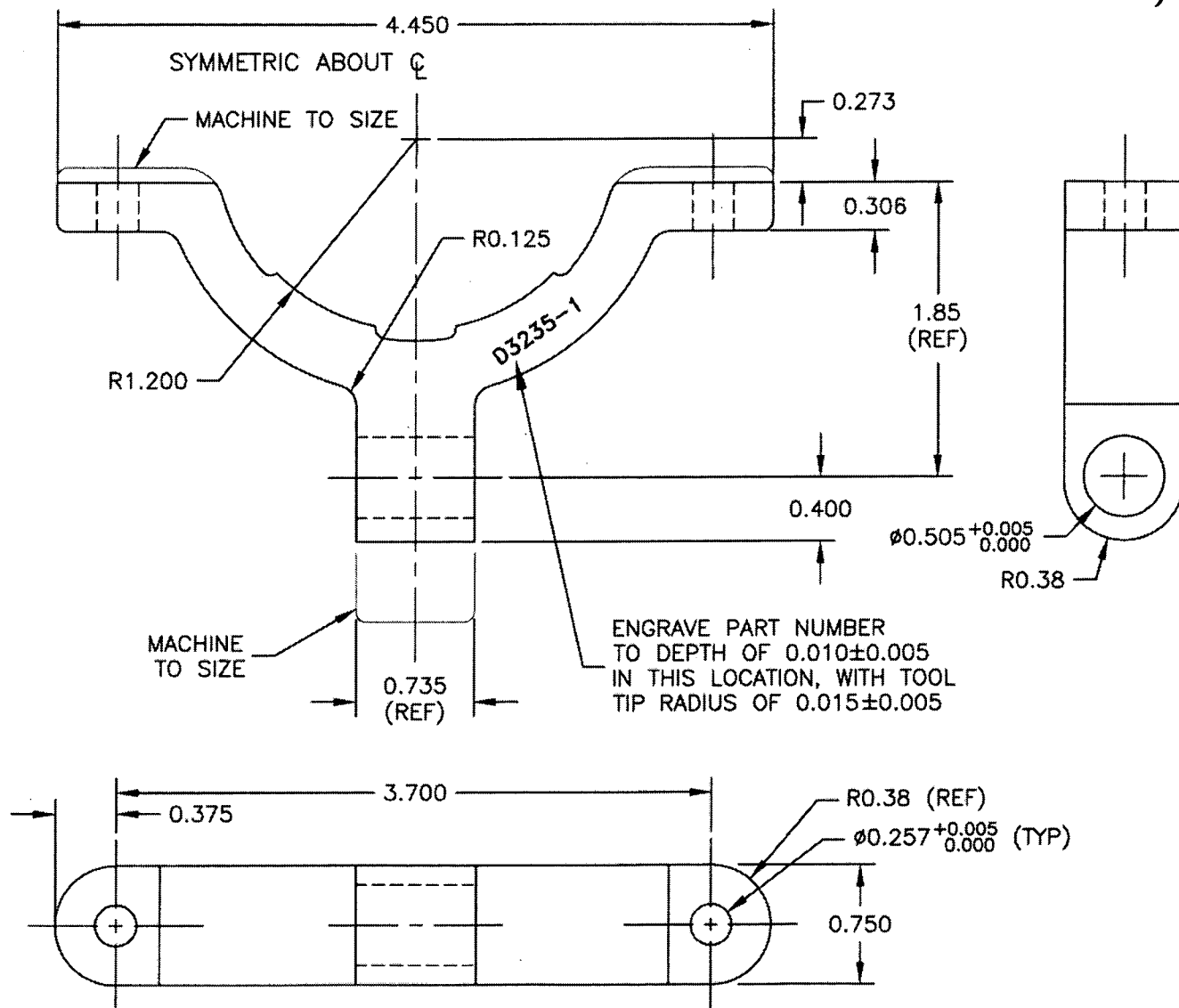
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3235	REV. A SHEET 1 OF 1
DATE 04.03.02		TITLE MOUNTING LUG	SCALE 1:1
A	04.03.02	NEW ISSUE	

RELEASED
040405 *#*

ulu 62214



D3235-1 MOUNTING LUG

MAKE FROM EXTRUSION D2423

BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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NOTE: Date & initial all entries



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0
Tel: (613) 678-3957
Fax: (613) 678-3956

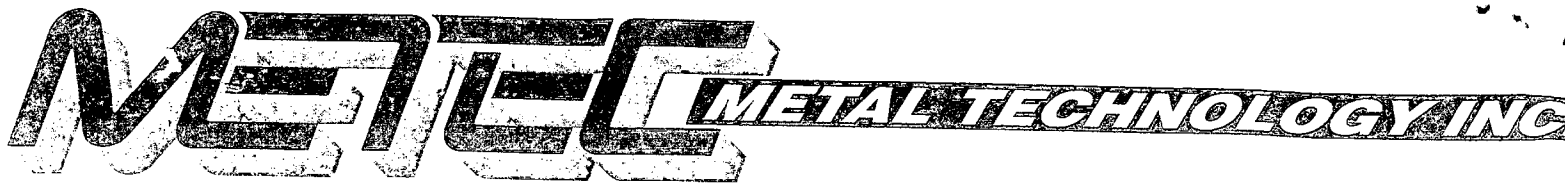
Delivery Slip No.: 17541

Date: Oct 29, 2010

Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 12709	Sold By: Walz, Christian D.
Shipped By: our truck	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D3394-3 Lug as per drawing D3394 Rev.B Material supplied by DART D2423 B45800	Each	40		
D3394-3 Lug as per drawing D3394 Rev.B Material supplied by DART D2423 B45800	Each	24		
D2731-7 Lug as per drawing D2731 Rev.C Material supplied by DART D2423 B45800	Each	24		
D2731-7 Lug as per drawing D2731 Rev.C Material supplied by DART D2423 B45800	Each	20		
D2230-3 Mounting Lug as per drawing D2230 Rev.G Material supplied by DART D2423 B45800	Each	100		
D2230-3 Mounting Lug as per drawing D2230 Rev.G Material supplied by DART D2423 B45800	Each	80		
D3235-1 Mounting Lug as per drawing D3235 Rev.A Material supplied by DART D2423 B45800 <i>8/10/14/14</i>	Each	50	50	
D2230-1 Mounting Lug as per drawing D2230 Rev.G Material supplied by DART D2423 B45800	Each	100	50	
D4091-1 Lug as per drawing D4091 Rev.A Material supplied by DART D2423 B45800	Each	10	10	
Received by _____		Thank you for your order!		



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:


same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
50	D3235-1	Mounting Lug	12709
50	D2230-1	Mounting Lug	12709
10	D4091-1	Mounting Lug	12709

MATERIAL: Supplied by DART D2324 45800

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, October 29, 2010